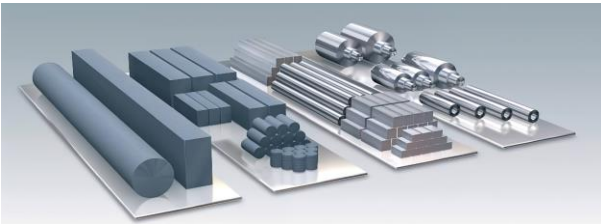




Gontermann-Peipers

Standard Product Range Continuous Casting

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GP Continuous Casting

Geometry

- Great range of standard dimensions in round and rectangular
- Customized geometries beyond standard product range on request
- Product range is completed by chill casting range

Length

- Standard length 3150 mm
- Special lengths on request

Machining

- Raw, pre-machined, machined
- Sawing, peeling, turning, milling, drilling, honing

Material

- Standard range in lamellar graphite cast iron (GJL, grey iron) and nodular graphite cast iron (GJS, DCI)
- Nodular graphite cast iron free from wear increasing cementite phase for excellent machinability
- Special materials on request
- Material number (e. g. 5.1203) according to EN 16482

Quality Assurance

- Certified according to DIN EN ISO 9001 / 14001 / 50001
- Computer based production process control
- Certificates according to DIN EN 10204
- External approvals on request
- Non-destructive testing at expert level certified according to DIN EN ISO 9712 - Level 2 and 3: UT, PT, MT and VT
- Dimensional tests and testing of form and positional tolerances
- GP laboratory accredited according to DIN EN ISO / IEC 17025:2018
- Approvals DNV (GL) / LR / TÜV (AD-2000 - W 0 / TRD100 & DGRL-Richtlinie 2014/68/EU)

Availability

- About 5000 t on Stock
- Incl. a wide variety of special geometries
- Short delivery times via frame agreements and special stock

Technische Informationen

Machining Allowances (DIN EN 16482)

The machining allowance refers to the radius or half the width of the bar

Round \bigcirc Continuous casting diameter D	Min. machining allowance	
	GJL	GJS
20 < D ≤ 50	1,5 mm	2,0 mm
50 < D ≤ 100	2,5 mm	3,0 mm
100 < D ≤ 200	3,5 mm	4,5 mm
200 < D ≤ 300	5,5 mm	6,5 mm
300 < D ≤ 400	6,5 mm	7,5 mm
400 < D ≤ 500	7,5 mm	8,5 mm
500 < D ≤ 650	10 mm	12 mm

Rectangular \square Length B of longest edge	Min. machining allowance	
	GJL	GJS
20 < B ≤ 50	2 mm	3 mm
50 < B ≤ 100	3 mm	4 mm
100 < B ≤ 200	4 mm	5 mm
200 < B ≤ 300	6 mm	7 mm
300 < B ≤ 400	7,5 mm	8,5 mm
400 < B ≤ 500	9 mm	10 mm
500 < B ≤ 650	12 mm	14 mm

Straightness/Bending (DIN EN 16482)

= Maximum deviation of the casting from a straight line for $\varnothing > 50$ mm.

For smaller diameters, the straightness must be agreed upon

Bar length L	Maximum deviation	
	raw (as cast)	annealed
1000 mm	2 mm	3 mm
2000 mm	4 mm	6 mm
3000 mm	6 mm	9 mm

Other Aspects

Other material properties and geometrical specifications as e. g.

- ovality
- surface shape
- mechanical properties
- structure

are described in the standard DIN EN 16482.

Strangguss Rund ○

D [mm]	EN-GJL-			400-15C	500-7C	EN-GJS-		GJS- 500-7CD
	250C	300C	HB150			600-3C	700-2C	
	5.1203	5.1308	5.1103			5.3126	5.3203	
40	●		●	●				
45	●		●	●				
50	●		●	●	●		●	
55	●	●	●	●				
60	●	●	●	●				
65	●		●	●	●		●	●
70	●	●	●	●	●	●	●	●
75	●		●	●				●
80	●	●	●	●				●
85	●		●	●				
90	●	●	●	●	●		●	●
95	●	●	●	●	●	●	●	●
100	●	●	●	●	●	●	●	●
105	●	●	●	●				●
110	●	●	●	●				●
112	●			●				
115	●	●	●	●	●	●	●	●
120	●	●	●	●	●	●	●	●
125	●		●	●	●	●	●	●
130	●	●		●				●
135	●			●				●
140	●	●	●	●				●
145	●			●				
150	●	●	●	●	●	●	●	
155	●			●	●			
160	●	●		●	●	●	●	●
165	●			●				
170	●	●		●				●
180	●	●		●				
190	●	●		●				●
200	●	●		●				
210	●	●		●	●	●	●	●
220	●	●		●				●
230	●	●		●				●
240	●			●				●
250	●	●		●				●
260	●			●	●	●	●	●
270	●			●				●
280	●			●	●	●	●	●
290	●			●				
300	●			●	●	●	●	●
310	●	●		●				
320	●			●				
330	●			●	●	●	●	●
340	●			●				
350	●			●				●
360	●			●				
370	●			●				
380	●			●				
400	●			●				
410	●			●				
420	●			●				●
450	●			●				
520	●			●				
D [mm]	250C	300C	HB150	400-15C	500-7C	600-3C	700-2C	GJS- 500-7CD
	5.1203	5.1308	5.1103	5.3126	5.3203	5.3204	5.3303	

Strangguss Vierkant □

BxH [mm]	EN-GJL-		EN-GJS-			BxH [mm]	EN-GJL-		EN-GJS-		
	250C	HB150	400	500	600		250C	HB150	400	500	600
	5.1203	5.1103	-15C	-14C	-3C		5.1203	5.1103	-15C	-14C	-3C
40x40	●	●				120x80					
50x40	●	●				120x120	●		●		
50x45	●	●				122x87			●	●	
50x50	●	●				125x125	●		●		
55x55	●	●	●			130x50		●			
60x40	●	●				130x60	●				
60x50	●	●				130x80	●				
60x60	●	●	●			130x90	●		●		
65x65	●	●				130x100	●				
70x40	●	●				130x110	●				
70x50	●	●		●		130x130	●		●		
70x60	●	●				135x60			●		
70x70	●	●	●			135x85			●		
75x55			●			135x91			●		
75x75	●	●				135x91			●		
77x65			●			135x115			●		
80x30	●	●				140x50	●	●			
80x40	●	●				140x60	●	●			
80x50	●	●				140x70	●				
80x60	●	●				140x80	●				
80x70	●	●		●		140x100			●		
80x80	●	●	●			140x110	●				
85x55				●		140x124			●		
85x85	●	●	●			140x140	●		●		
90x30	●	●				145x90			●		
90x50	●	●	●			145x135			●	●	
90x55	●	●	●			145x145			●		
90x70	●	●	●	●		150x60	●	●			
90x80	●	●				150x90			●	●	
90x90	●	●	●			150x92			●		
95x45				●		150x120	●				
95x60			●	●		150x130			●		
95x95	●	●				150x150	●		●		
100x40	●	●				155x105			●		
100x50	●	●	●			155x140			●		
100x60	●	●				160x50	●				
100x70	●	●				160x100	●				
100x80	●	●	●			160x110			●		
100x90	●	●				160x120	●				
100x100	●	●	●	●	●	160x130			●		
105x105			●	●		160x140	●				
110x30	●	●				160x160	●		●		
110x50	●	●				165x130			●		
110x60	●	●	●			170x100			●		
110x70	●	●				170x140			●		
110x110	●		●			170x170	●				
112x92			●			180x60	●				
115x85	●					180x150			●		
115x100	●					180x180	●		●		
115x115	●		●			183x163			●		
116x95			●			185x130	●				
118x105			●			185x165	●				
120x40	●	●				190x190	●				
120x50	●	●				195x150			●	●	
120x60	●					200x60	●				
120x70	●					200x100	●				
BxH [mm]	250C	HB150	400	500	600	BxH [mm]	250C	HB150	400	500	600
	5.1203	5.1103	-15C	-14C	-3C		5.1203	5.1103	-15C	-14C	-3C

Strangguss Vierkant □

BxH [mm]	EN-GJL-		EN-GJS-			BxH [mm]	EN-GJL-		EN-GJS-		
	250C	HB150	400	500	600		250C	HB150	400	500	600
	5.1203	5.1103	-15C	-14C	-3C		5.1203	5.1103	-15C	-14C	-3C
200x140			●								
200x150	●										
200x180			●								
200x200	●		●	●							
210x135			●								
210x210			●								
215x185			●								
220x70	●										
220x170			●								
220x220	●		●	●							
230x230			●								
240x190			●								
240x220			●								
240x240	●		●								
250x150	●										
250x220	●		●								
250x250	●		●								
260x260	●		●	●							
265x165											
265x265			●								
280x80	●										
280x185			●								
300x300	●										
320x220	●										
320x320	●		●								
330x330	●										
360x70	●										
360x360	●		●								
530x330	●	●	●								
610x410	●		●								
BxH [mm]	250C	HB150	400	500	600	BxH [mm]	250C	HB150	400	500	600
	5.1203	5.1103	-15C	-14C	-3C		5.1203	5.1103	-15C	-14C	-3C

● Werkstoffqualität EN-GJS-400-18C RT + LT in verschiedenen Abmessungen auf Anfrage